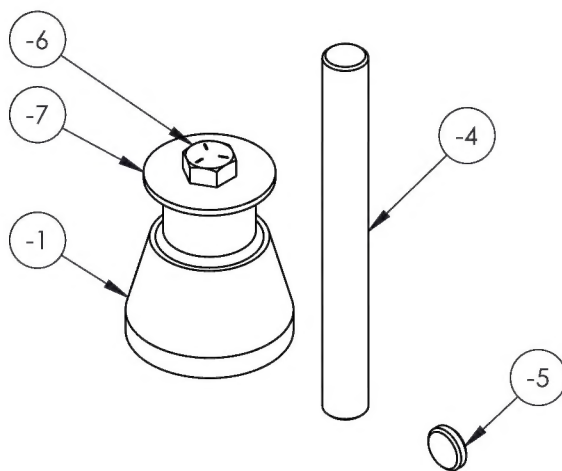


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CORRECTED AND COMPLETED FILE. IMPLEMENTED NEW TITLEBLOCK, BOM, & REVISION TABLE. ALSO DELETED OBSOLETE -2 & -3 TOOLS, RBT18531 IS THIER REPLACEMENT SOLD SEPARATELY.	3/5/2008	WP	DW
2	16-0278	UPDATED TO NEW DRAFTING STANDARD. -1, -4, -5 CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, DELETED WORK INSTRUCTIONS. -1 CH'D DIM WAS R.080 IS R.08, WAS .060 X 45° IS .06 X 45°, WAS 5/16-24 UNF DEPTH .625 IS 5/16-24 UNF -2B $\nabla$ .62. CH'D ENGRAVE NOT WAS ENGRAVE P/N IS ENGRAVE T/N, S/N, "MADE IN USA". -4 CH'D DIM WAS .030 X 45° IS .03 X 45°, ADDED DATUM A AND GD&T FEATURE CONTROL FRAME. -5 CH'D DIM WAS .030 X 45° IS 2X .03 X 45°.	1/11/2017	RJC	JAG

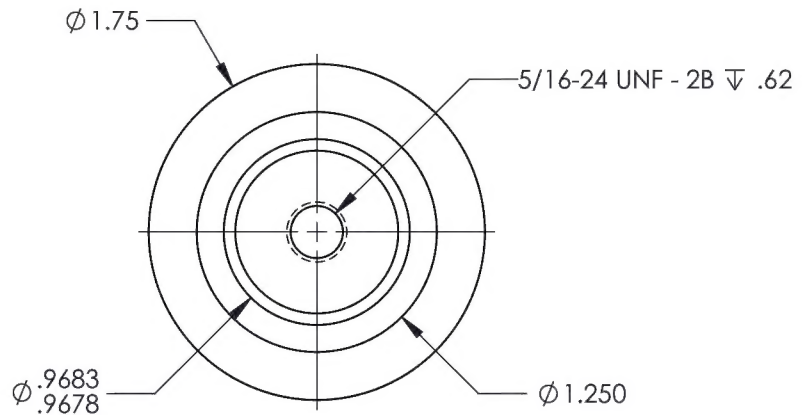
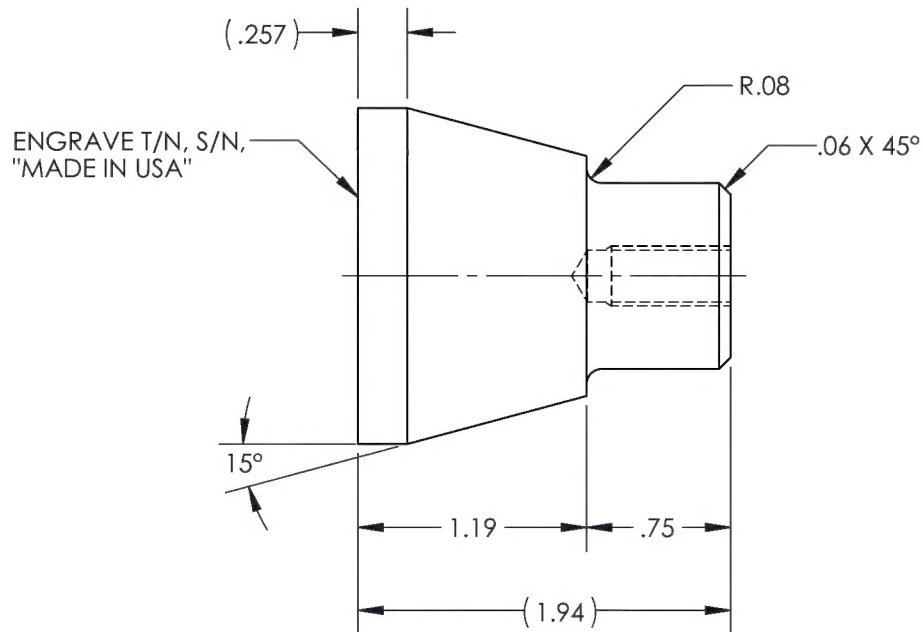
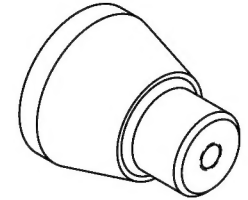


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	TRUNNION CENTERING SHAFT	4140/4142		2
			-4	1	TRUNNION INNER RACE REMOVAL PLUG	4140/4142		3
			-5	1	TRUNNION BEARING RACE PLUG	4140/4142		4
		B/O	-6	1	BOLT	STEEL	AN5-4A	1
		B/O	-7	1	WASHER	STEEL	AN970-5	1

<b>DART AEROSPACE</b>	
TITLE <b>T/R TRUNNION CENTERING TOOLS</b>	
DWG NO. <b>RBT18517</b>	REV <b>2</b>
MAT'L <b>REAT</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° ✓
TREAT <b>FINISH</b>	
SPEC	
DRAWN BY: <b>COLE</b>	
CHECKED: <b>DUERFELDT</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR: <b>ANDERSON</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: <b>LINDSAY</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: <b>GILBERT</b>	USED ON MODEL <b>BELL 206A &amp; B</b>
SCALE <b>1:2</b>	DATE <b>4/25/2003</b>
SHEET 1 OF 4	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0278	-1 CH'D DIM WAS R.080 IS R.08, WAS .060 X 45° IS .06 X 45°, WAS 5/16-24 UNF DEPTH .625 IS 5/16-24 UNF -2B $\nabla$ .62, CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, CH'D ENGRAVE NOT WAS ENGRAVE P/N IS ENGRAVE T/N, S/N, "MADE IN USA", DELETED WORK INSTRUCTIONS.	1/11/2017	RJC	JAG

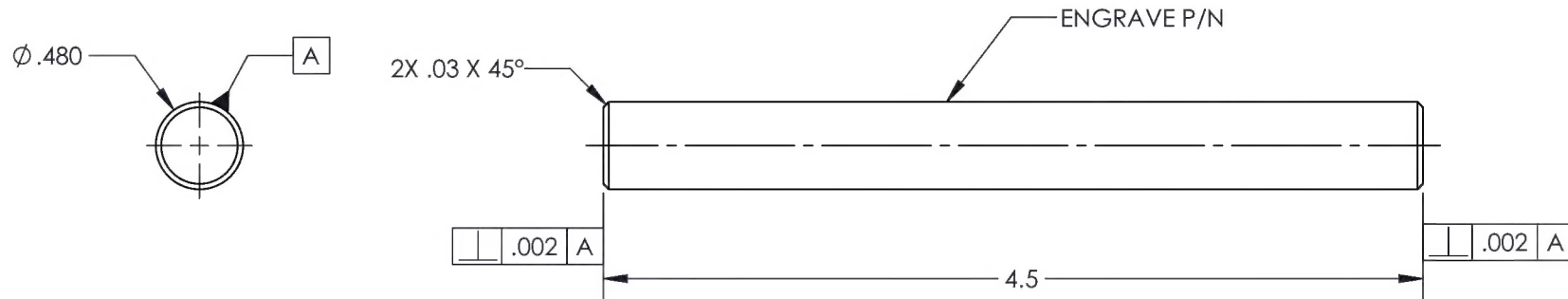
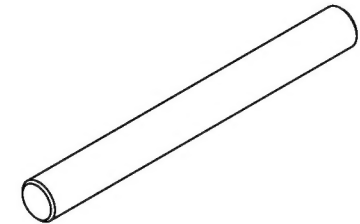


(-1)  
TRUNNION CENTERING SHAFT

<b>DART AEROSPACE</b>	
TITLE <b>T/R TRUNNION CENTERING TOOLS</b>	
DWG NO. <b>RBT18517-1</b>	REV <b>2</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX $\pm$ .01 ANGLES $\pm$ 5°
DRAWN BY: COLE	.X $\pm$ .1 SURFACES = 125 $\checkmark$
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 4/25/2003	USED ON MODEL
SHEET 2 OF 4	BELL 206A & B

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0278	-4 CH'D DIM WAS .030 X 45° IS .03 X 45°, CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, DELETED WORK INSTRUCTIONS. ADDED DATUM A AND GD&T FEATURE CONTROL FRAME.	1/11/2017	RJC	JAG



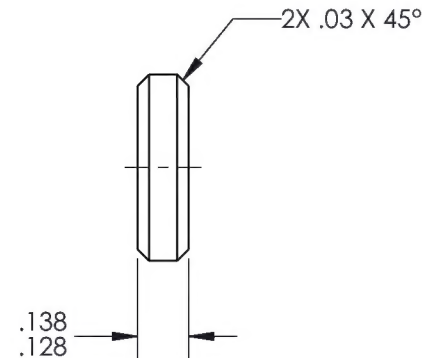
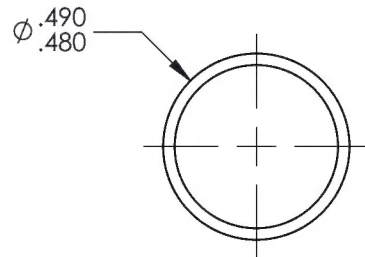
(-4)

TRUNNION INNER RACE REMOVAL PLUG

<b>DART AEROSPACE</b>	
TITLE <b>T/R TRUNNION CENTERING TOOLS</b>	
DWG NO. <b>RBT18517-4</b>	REV <b>2</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: COLE	.X ± .1 SURFACES = 125°
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 4/25/2003	USED ON MODEL
SHEET 3 OF 4	BELL 206A & B

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0278	-5 CH'D DIM WAS .030 X 45° IS 2X .03 X 45°, CH'D MATERIAL WAS 4140 IS 4140/4142, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, DELETED WORK INSTRUCTIONS.	1/11/2017	RJC	JAG



(5)

TRUNNION BEARING RACE PLUG

<b>DART AEROSPACE</b>	
TITLE <b>T/R TRUNNION CENTERING TOOLS</b>	
DWG NO. <b>RBT18517-5</b>	REV <b>2</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: COLE	.X ± .1 SURFACES = 125°
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 4/25/2003	USED ON MODEL
SHEET 4 OF 4	BELL 206A & B